

Date: Wednesday, 17/09/2008 10:40:19 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE
Job Number	: 42053		
Estimate Number	: 13558		
P.O. Number	:	Part Number	: D38133
This Issue	: 17/09/2008 S.O. No. :	Drawing Number	: D3813 PREL <i>ppfo</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: PREL
Previous Run	:	Material	:
Written By	: <i>JLM 08.09.17</i>	Due Date	: 24/09/2008
Checked & Approved By	:	Qty:	3 Um: Each
Comment	: Est Rev: A New Issue 08-09-03 JLM Verified By: EC		

Additional Product

PRELIMINARY ISSUE

Job Number:

**PRELIMINARY ISSUE**

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X03000	6061-T6 Bar .750 x 3.00
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Comment: Qty.: 0.5040 f(s)/Unit Total : 1.5120 f(s)
 6061-T6 Bar .750 x 3.00
 BATCH: *M104741*

J.L 08/09/21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank 5.725 " long

J.L 08/09/21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA778 Rev. *A* & Dwg D3813 Rev. *A*

2-Deburr per dwg D3813

3-Finish tapping hole to final depth as per Dwg D3813

DJP J.L 08/09/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP J.L 08/09/22

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mx 08/09/24

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 42053

Part Number: D38133

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

410

08-10-02

(X4)

7.0

POWDER COATING

POWDER COATING



M 109152



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MASK THREADED HOLE PRIOR TO POWDER COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-10

320 OF

8-40

M-1 08/10/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-03

(XC)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

for Dac2 D3813-041

18 08/10/03

(X4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08-09-17

RELEASED

AUTH

DATE

u 08/10/03

NA

DART AEROSPACE LTD		Work Order: 42053
Description: hinge		Part Number: D3813-3
Inspection Dwg: D3813 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

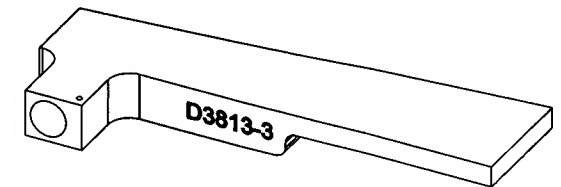
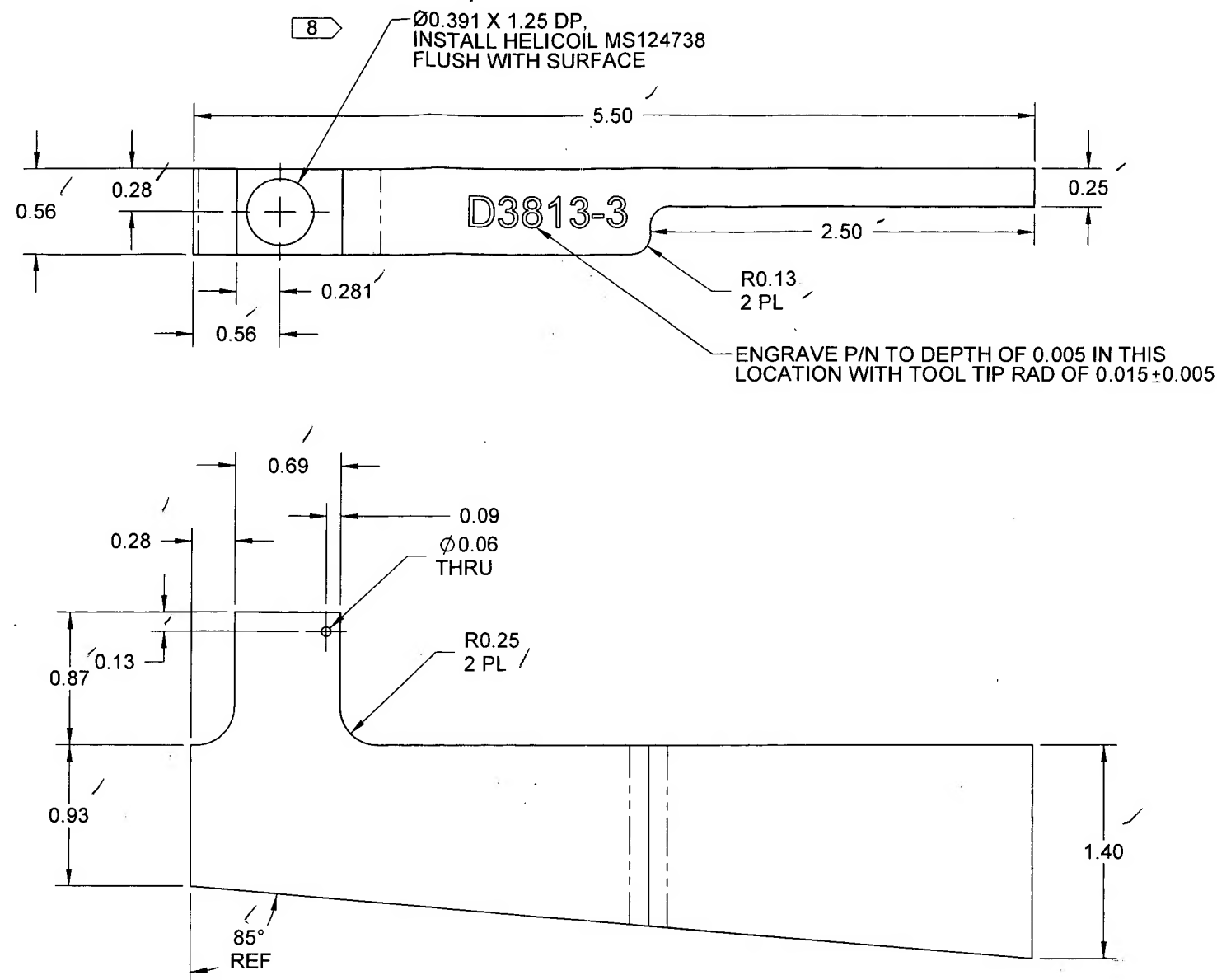
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.56	$\pm .030$.565	✓			
.28	$\pm .030$.28	✓			
.56	$\pm .030$.561	✓			
.281	$\pm .010$.281	✓			
Ø.391	$\pm .006$ $- .001$.391	✓			
1.25 deep	$\pm .030$	1.240	✓			
1.13	$\pm .030$.130	✓			
2.50	$\pm .030$	2.500	✓			
.25	$\pm .030$.255	✓			
5.50	$\pm .030$	5.503	✓			
.69	$\pm .030$.690	✓			
.28	$\pm .030$.280	✓			
.13	$\pm .030$.120	✓			
.87	$\pm .030$.873	✓			
.93	$\pm .030$.925	✓			
85°	$\pm 1/2^\circ$	85°	✓			
1.40	$\pm .030$	1.398	✓			
1.25	1.25 $\pm .030$	1.25	✓			
.06	$\pm .004$ $- .001$.062	✓			
.09	$\pm .030$.090	✓			

Measured by: 51	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 08/09/22	Date: 08/09/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



PRELIMINARY ISSUE



D3813-3 HINGE, LOWER DOOR

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3813	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	08.09.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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